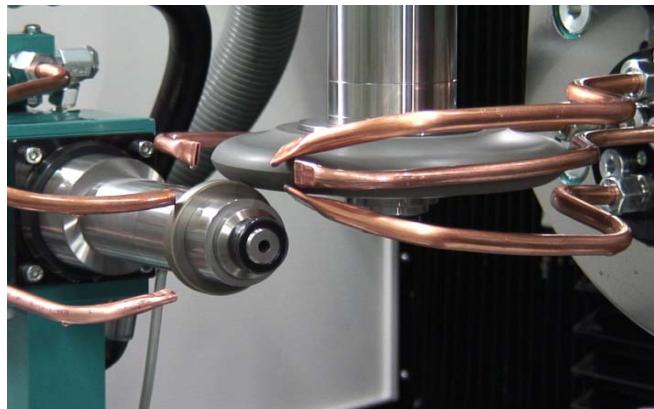


## Drillfluting conventional Ø32 Z2

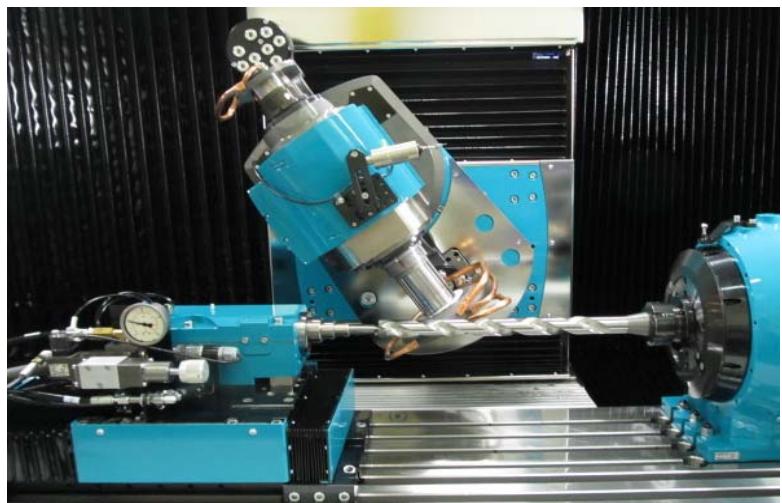
A05-010

Grinding strategy for flute: 28 passes of 0.4 mm feed plus 3 sparkoutpasses.



### 1. Cycletime for Production

Workpiece:	Ø 32 mm, Z 2, Length 370 mm, Helix 32°	
Material HSS		
Operations	 Flute 1	 Dress
Feed [mm/Min]	8400	300
Power [kW]	15	1
Cutting speed [m/s]	70	24
Used wheels	 1	 1
Grinding time [s]	719	55
Total cycle time	12 Min 53	



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1

DXF Ø200 C80



### 3. Machine and Software Requirements

Machines: CORVUSgds 26kW

Coolant: Synthetic Oil, pressure 16 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Tailstock heavy

Responsible engineer: OP, 24.3.15

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